

Date: Tuesday, 11/21/2006 1:15:28 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 SKIDTUBE "I" BEAM
 Job Number : 29604
 Estimate Number : 10346
 P.O. Number : N/A Part Number : D2596
 This Issue : 11/21/2006 S.O. No. : N/A Drawing Number : D2596 REV C
 Prsht Rev. : NG Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C
 Previous Run : 29455 Material : N/A
 Due Date : 11/28/2006 Qty: 24 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D
 M

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25003100 Ex'n -I' Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Extrusion "I" Beam Web 4"

Pick;

Qty Part Number Description Batch
 1 D2500-3-100 Extrusion

Batch

B25751

RT 06 11 22

(24)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Cut D2500-3-100 to length: 99.5" RT 06-11-22 (24)

2- Use Jig DT8093 to drill pilot holes #30 RT 06-11-22 (24)

3- Open to 0.625" diameter using a uni-bit RT 06-11-22 (24)

4- Deburr RT 06-11-22 (24) / m.g 06/11/23

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

M.R 06/11/23 (24)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 6-11-23 (24)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

DP 6-11-23 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/11/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 29604

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(24)

Comment: FINAL INSPECTION/W/O RELEASE

06/11/24

Job Completion



06.11.24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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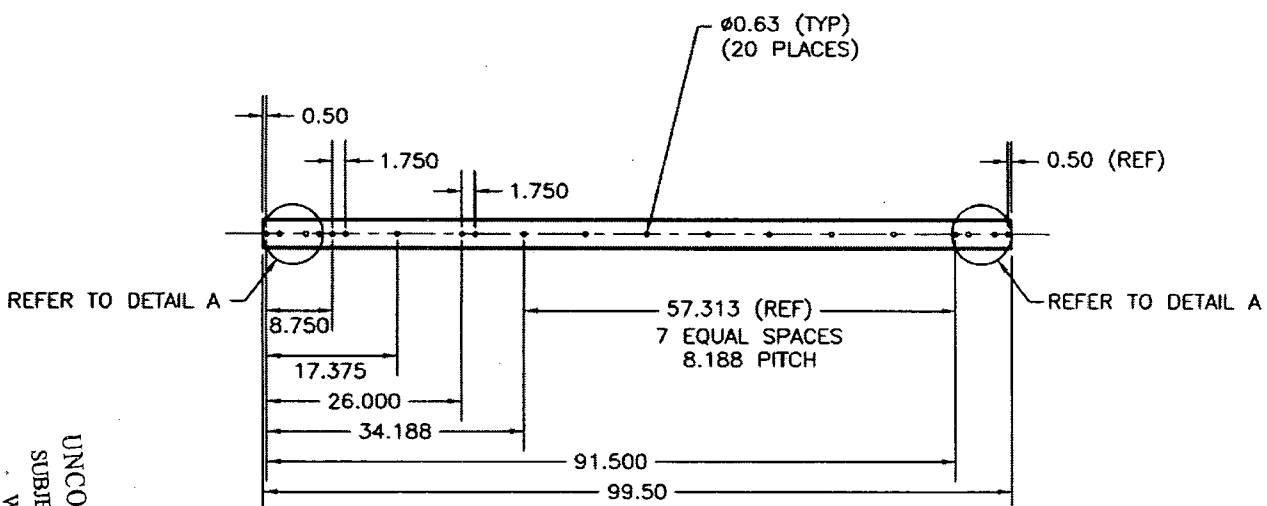
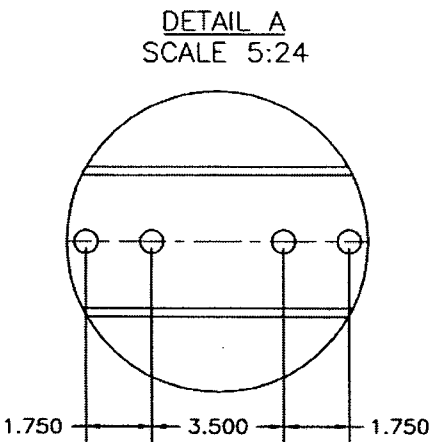
NOTE: Date & initial all entries

DART



RELEASED
98.09.17 b3

DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D2596	SHEET 1 OF 1
DATE	98.09.14	TITLE	205 WEB	SCALE	1:24	
A	96.09.16	NEW ISSUE				
B	97.07.23	Ø0.63 HOLE WAS Ø0.56				
C	98.09.14	INCORPORATED DEO 9097				



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29604